4

5

6

7

8

9

10

11

12

13

14

15

We claim:

- A method of producing metal tubing in a planetary
 skew rolling mill which comprises the steps of:
 - (a) advancing a tubular metal bloom between a plurality of rolls of a planetary skew rolling mill, positioning a mandrel-shaped internal tool within said bloom and rolling the bloom with said rolls against said mandrel-shaped internal tool to a reduced wall thickness of a rolled tubing in a working position of said internal tool:
 - (b) upon approach of an end of said bloom to a region of said rolls, withdrawing said mandrel-shaped internal tool from said working position linearly by a predetermined distance in a direction opposite a direction of advance of the bloom; and
 - (c) upon said end passing said region of said rolls, displacing said mandrel-shaped internal tool linearly back into said position.
- 2. The method defined in claim 1, further comprising the step of sealing said end liquid tight by compressing said end with said rolls upon withdrawal of said mandrel-shaped internal tool from said position.

- 10 -

- 3. The method defined in claim 2 wherein said end is a
 leading end of the bloom.
- 1 4. The method defined in claim 2 wherein said end is a trailing end of the bloom.
- 5. The method defined in claim 2 wherein both a leading end and a trailing end of the bloom are sealed.
- 6. The method defined in claim 2 wherein at least two of said blooms are fed one after another though said region and a leading end of a subsequent bloom abuts a trailing end of a preceding bloom.
- 7. The method defined in claim 6 wherein a succession of said blooms are fed continuously through the planetary skew rolling mill.
- 8. The method defined in claim 2, further comprising the steps of measuring rotation of said tubing during rolling

- 3 thereof, and controlling at least one drive of the planetary skew
- 4 rolling mill to compensate for rotation of the tubing about a
- 5 longitudinal axis thereof.
- 1 9. The method defined in claim 8 wherein the
- 2 controlled drive is a main drive of said rolling mill.
- 1 10. The method defined in claim 8 wherein the
- 2 controlled drive is a superimposed drive of said rolling mill.
- 1 11. The method defined in claim 2, further comprising
- 2 the step of cooling at least one of said bloom and said tubing
- 3 with a liquid cooling medium.
- 1 12. A planetary skew rolling mill for producing metal
- 2 tubing,
- 3 comprising:
- a plurality of rolls in a planetary skew rolling mill
- 5 configuration and a mandrel-shaped internal tool within a tubular
- 6 metal bloom for rolling the bloom with said rolls against said
- 7 mandrel-shaped internal tool to a reduced wall thickness of a
- 8 rolled tubing in a working position of said internal tool; and

- 12 -

9 a device connected to said internal tool and effective 10 upon approach of an end of said bloom to a region of said rolls 11 for withdrawing said mandrel-shaped internal tool from said working position linearly by a predetermined distance in a 12 13 direction opposite to a direction of advance of the bloom, 14 effective upon said end passing said region of said rolls for 15 displacing said mandrel-shaped internal tool linearly back into 16 said position.

- 1 13. The planetary skew rolling mill defined in claim
- 2 12 wherein said device is a linear actuator.
- 1 14. The planetary skew rolling mill defined in claim
- 2 12 wherein said linear actuator is a hydraulic actuator.
- 1 15. The planetary skew rolling mill defined in claim
- 2 12 wherein said linear actuator is an electrical actuator.

- 13 -